

**Work Order ID 72276**

Wednesday, July 20, 2011 3:47:32 PM

Page 1

Item ID: D4005-11

Accept

Revision ID:

Item Name: Finishing Strip

Start Date: 7/20/2011 Start Qty: 4.00

Required Date: 7/29/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:                      Date: 11-07-20 Tooling:                      Date:                       
QC:                      Date:                      SPC (Y/N):                      Date:                     

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4005

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.00

B11-8-2

16

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-8-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sulosloz

(711)

130



Brake NC

Brake NC

Bend as per dwg

0.00

Memo

0.00

SP 11603103

(11)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulosloz

(11)

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D4005-11

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Revision ID:

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Start Date: 7/20/2011 Start Qty: 4.00

Required Date: 7/29/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11x6 ML 11/08/08

11x6 11/08/08 ML

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: 106

0.00



Packaging

Memo

0.00

Packaging

11/8/08 SF 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 72276**

Wednesday, July 20, 2011 3:47:32 PM



Page 4

Item ID: D4005-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Finishing Strip

Start Date: 7/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept Reject Reject Insp.  
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/09

ME  
11-08-08

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Wednesday, July 20, 2011 3:47:39 PM

Page 1

Work Order ID: 72276



Parent Item: D4005-11



Parent Item Name: Finishing Strip

Start Date: 7/20/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B  
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

100

sf

105.9000

0.303

1.275789

3.5



B11-8-2

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT22

105.9

111699

0.5

113189

23.9

118243

81.5

113189

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

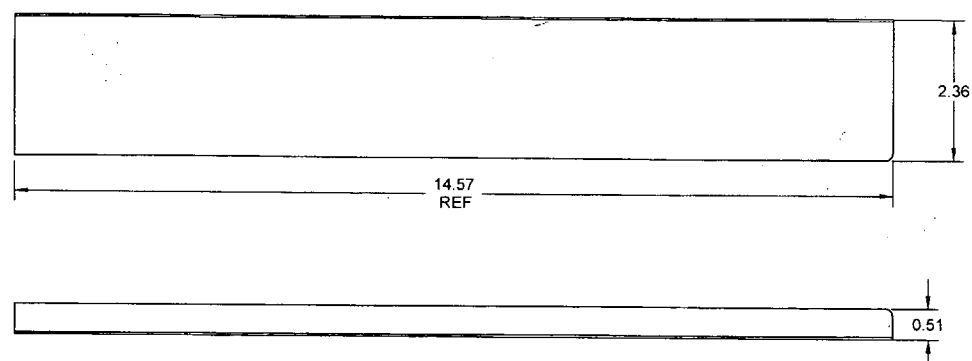
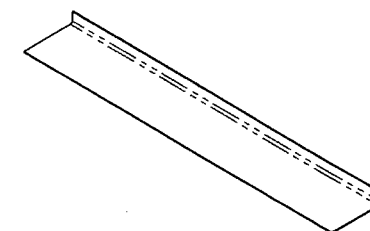
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**NOTE:** Date & initial all entries

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 72274

*PL11-07-20*



**D4005-11 FINISHING STRIP**

**RELEASED**  
 2010-05-05

- NOTES:
- 1) MATERIAL: MADE FROM D4005-11F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-11" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.13 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4005</b> REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 12 OF 15
APPROVED	<i>[Signature]</i>	TITLE <b>RESTRAINT</b> SCALE
DE APPR.	<i>[Signature]</i>	NTS
DATE	<b>10.02.05</b>	COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

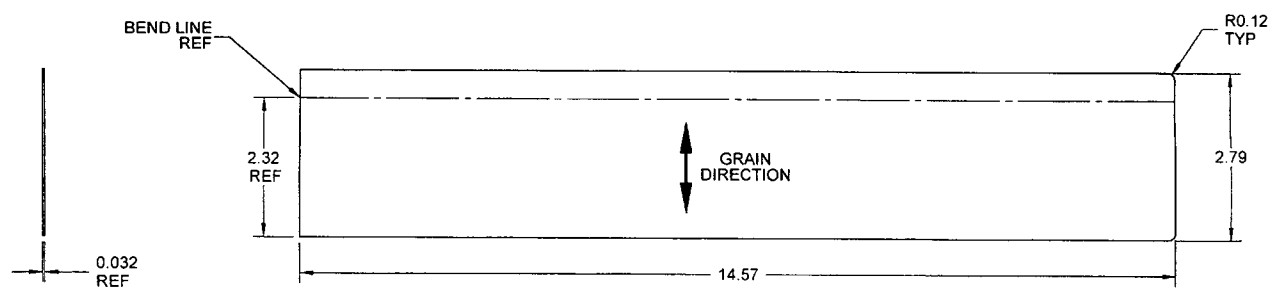
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

172274



**D4005-11F FLAT PATTERN**

**RELEASED**  
2010-05-05  
MD

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.032
- OR 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.032
- OR 5052-H32 ALUMINUM SHEET  
PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209  
REF DART SPEC M5052H32S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4005	SHEET 13 OF 15
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DE APPR.		RESTRAINT	NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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